

Date: Monday, 27/04/2009 11:30:50 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 47550	
Estimate Number : 10955	
P.O. Number :	Part Number : D2565201
This Issue : 27/04/2009 S.O. No. :	Drawing Number : D2565 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 36514	Material :
Written By :	Due Date : 04/05/2009 Qty: 9 Um: Each
Checked & Approved By : <u>JUD 09.04.27</u>	
Comment : Est: D 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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**Comment:** Qty.: 2.0124 f(s)/Unit Total : 20.1243 f(s)
 Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall
 (M304TR0750W049)
Batch No: M107518 ⑦SB 09/04/28 ⑨

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC

Punch as per Dwg D2565 using DT 8313

SB 09/04/28 ⑨

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1
 Drill hole as per Dwg D2565 (one end only)
 Deburr
M-L 09/05/01

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEPS 08/05/04 ⑧

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 8:00OVEN TEMPERATURE: 400°FINISH TIME: 8:30FL 09/05/07

⑨

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



yl



Comment: INSPECT POWDER COAT

09-05-07

(X9)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST270

88 09/05/07 (X9)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07

Job Completion



MP
09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

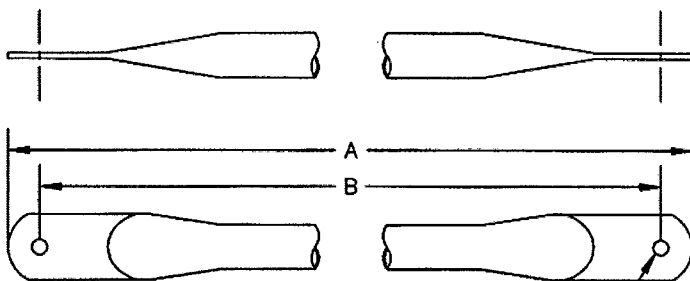
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

SHOP COPY
RETURN TO
ENGINEERING

GENERAL NOTES

- MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL (REF DART SPEC. M304TR0.750W0.049) ENSURE SEAMLESS TUBE IS USED
- FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

41550

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